

Work Order ID 63238

Tuesday, October 26, 2010 8:35:52 AM



Page 1

Item ID: D3536-23

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 10/26/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-10-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

B10-11-2

(15)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-11-2

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S1014/03

(15)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63238

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Page 2

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Customer:

Reference:

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location

JP

0.00



Packaging

Memo

0.00

Packaging

N111351 (152)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/04
MF
10-11-4

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NOTE: Date & initial all entries

Picklist Print

Tuesday, October 26, 2010 8:35:51 AM

Page 1

Work Order ID: 63238

Parent Item: D3536-23

Parent Item Name: Gasket





Start Date: 10/26/2010

Required Date: 10/29/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	538.4220	1.3365	17.82	20.1		
NEOPRENE SHEET 0.063											1810-11-2		

Location

Loc Qty

Loc Code

MAT

538.422

115500

138.422

115916

400

115500

(15)

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order: 63238
Description: Gasket		Part Number: D3536-23
Inspection Dwg: D3536	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/-0.030	52.85	x		T B01	
48.20	+/-0.030	48.26	x		T	
44.70	+/-0.030	44.70	r		T	
39.31	+/-0.030	39.31	x		T	
33.92	+/-0.030	33.92	x		T	
28.53	+/-0.030	28.53	o		T	
23.14	+/-0.030	23.14	r		T	
17.75	+/-0.030	17.75	r		T	
14.25	+/-0.030	14.25	7		T	
9.50	+/-0.030	9.50	q		T	
4.75	+/-0.030	4.75	7		T	
8.00	+/-0.030	8.00	=		T	
16.00	+/-0.030	16.00	v		T	
24.00	+/-0.030	24.00	2		T	
32.00	+/-0.030	32.00	v		T	
39.00	+/-0.030	39.00	b		T	
48.00	+/-0.030	48.00	x		T	
0.30	+/-0.030	-300	x		V B02	
0.30	+/-0.030	-300	x		V	
1.89	+/-0.030	1.892	x		V	
Ø0.19	+0.005/-0.001	.190	x		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: B 10-11-2	Date: 10/4/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJJ/JLM	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

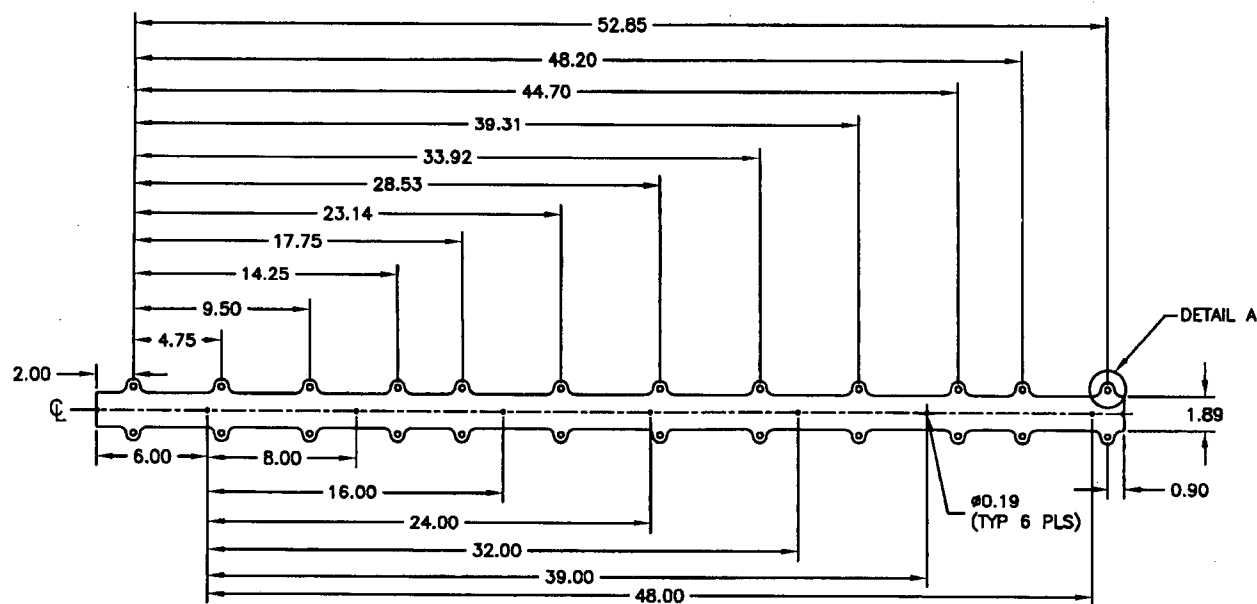
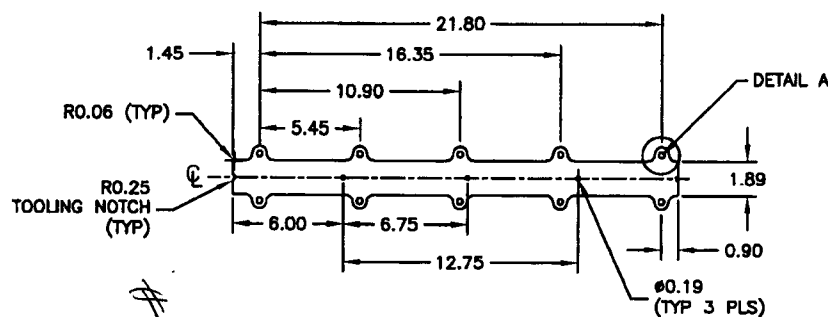
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NOTE: Date & initial all entries

DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 3 OF 6
		SCALE	1:10	

070212
RELEASED

**D3536-23 GASKET****D3536-25 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT \bar{C}
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

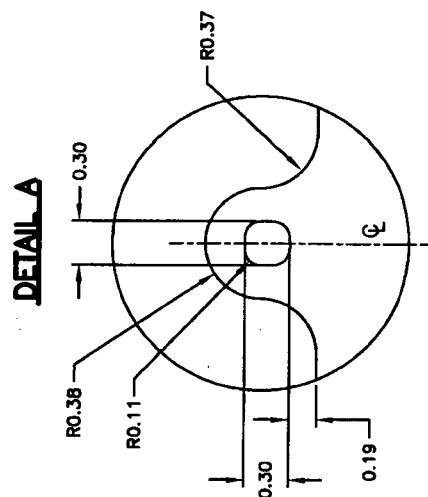
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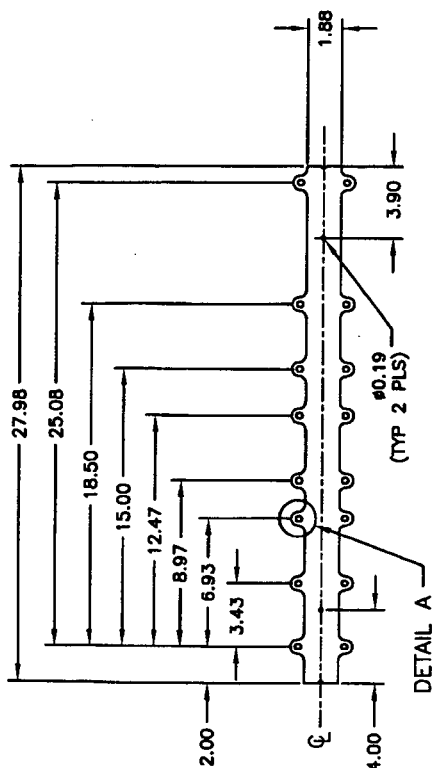


DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3536	REV. A SHEET 6 OF 6
DATE 06.10.25		TITLE GASKET	SCALE 1:10

RELEASED
07.02.12 **[Signature]**



#63038



D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

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W/O:		WORK ORDER CHANGES						
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